

PTO →  
2<sup>nd</sup> page

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# Work Order ID 111725

January-20-14 2:38:14 PM

**\*111725\***

Page 2

Item ID: D5017-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: PRELIM Stop **\*NS2\***  
Item Name: Support, 214 Fwd  
Start Date: 1/20/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 2/03/14 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				5	1		DAS 12 9-89 14/2/10
<b>*120*</b>	Memo	0.00							
QC									
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>	Memo	0.00							14/2/10 5 R
Packaging									
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>	Memo	0.00							MLJ 14-02-26
QC									
Quality Control									

POSITIVE RECALL  
EFFECTIVE 14-02-18 AUTH U  
RELEASED 5 DATE 14/02/24

Release Dwg To ME  
Per A 14-2-10

DQA:

Date: 14/03/05



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14-2-28

Work Order update only ☐

Work Order: <u>111725</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D5017-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3580</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator	X 14/02/03	100	I	→ A section of .500 by 1.000 inch long is missing in the clamp section → Operator ran the program with the A axis inverted like the other models but the actual part is program with A axis standard rotation RC no reverification done.	DAS 12 9-89 14/2/5	→ info has been added on folio to prevent of happening again AFS 14/02/05 SCRAP. ADD step to have set up / offset Re version \$190.85		DAS 27 9-89 14/02/06	DAS 16 9-89 14/02/05
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

No. of Parts were Run

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other No reverification or check test in place.	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
--	--	---	--	--

# Picklist Print

January-20-14 2:38:17 PM

Page 1

Work Order ID: 111725

**\*111725\***

Parent Item: D5017-1

**\*D5017-1\***

Parent Item Name: Support, 214 Fwd

Start Date: 1/20/14

Required Date: 2/03/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV.A NEW ISSUE JFS 14/01/20 VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5017-1TRN		Manufactured	No			100	Each	0.0000	1	4			
<b>*D5017-1TRN*</b>									<b>**</b>			<u>15.A 14/02/04</u>	
Support, 214 Fwd													

M 111721

3.0

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

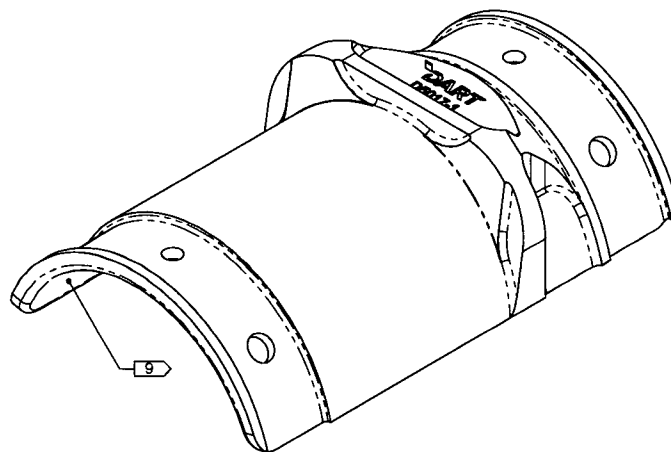
Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**D5017-1 SUPPORT, 214 FWD**

**NOTES:**

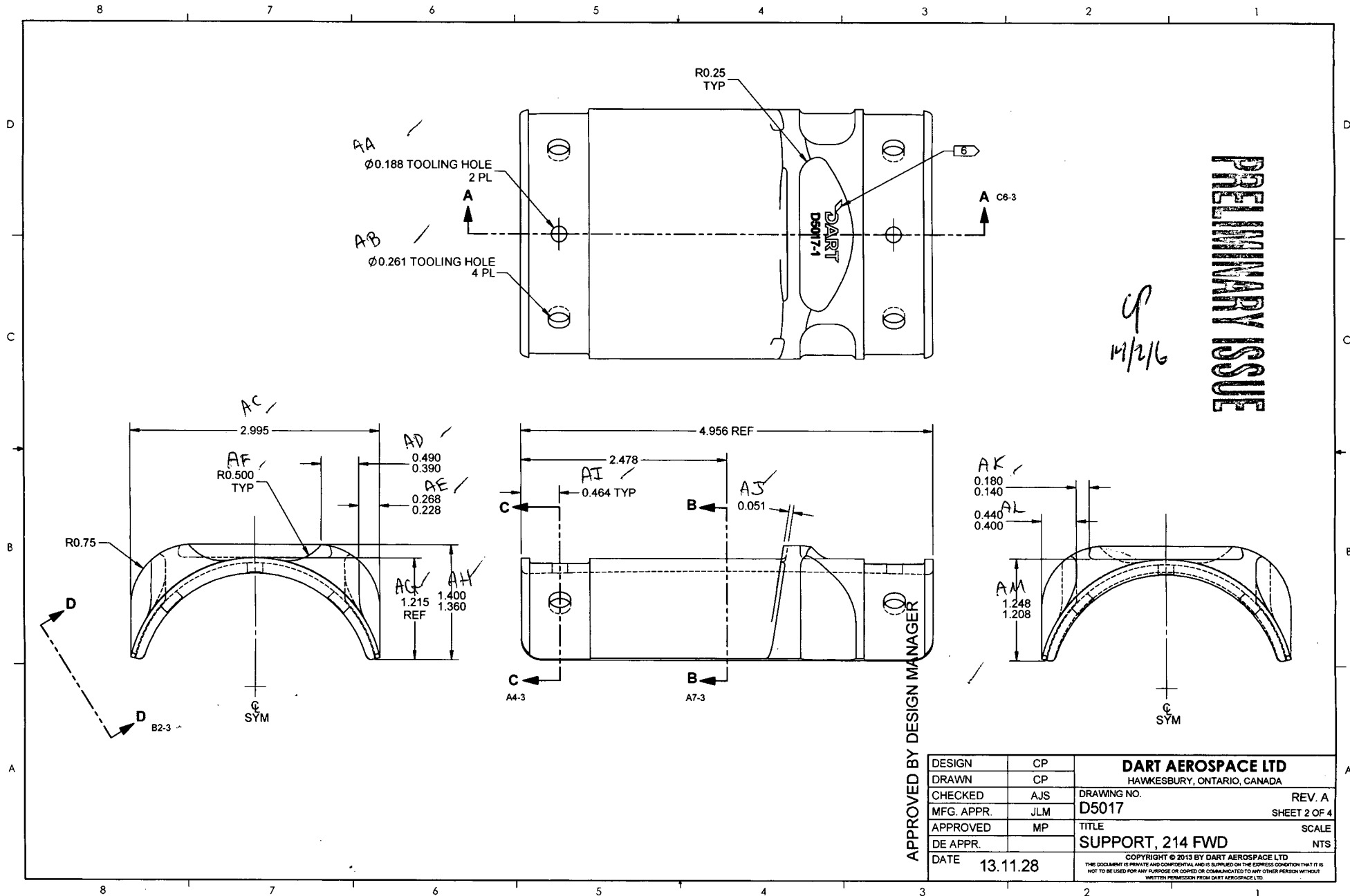
- 1) MATERIAL: MAKE FROM D5017-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N "D5017-1" IN THIS AREA WITH 0.125 HIGH X 0.010-0.020 DEEP LETTERING  
PER DART QSI 044 6.3
- 7) WEIGHT: 0.88 lbs
- 8) INNER CONCAVE SURFACE HAS A CONSTANT RADIUS OF R1.387 (REF) CUT ALONG AN R87.4 (REF) PATH (ie. TORUS SHAPE)
- 9) FOR ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIV.).  
APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE  
FOR 24 HOURS.

**PRELIMINARY ISSUE**

*P14/216*

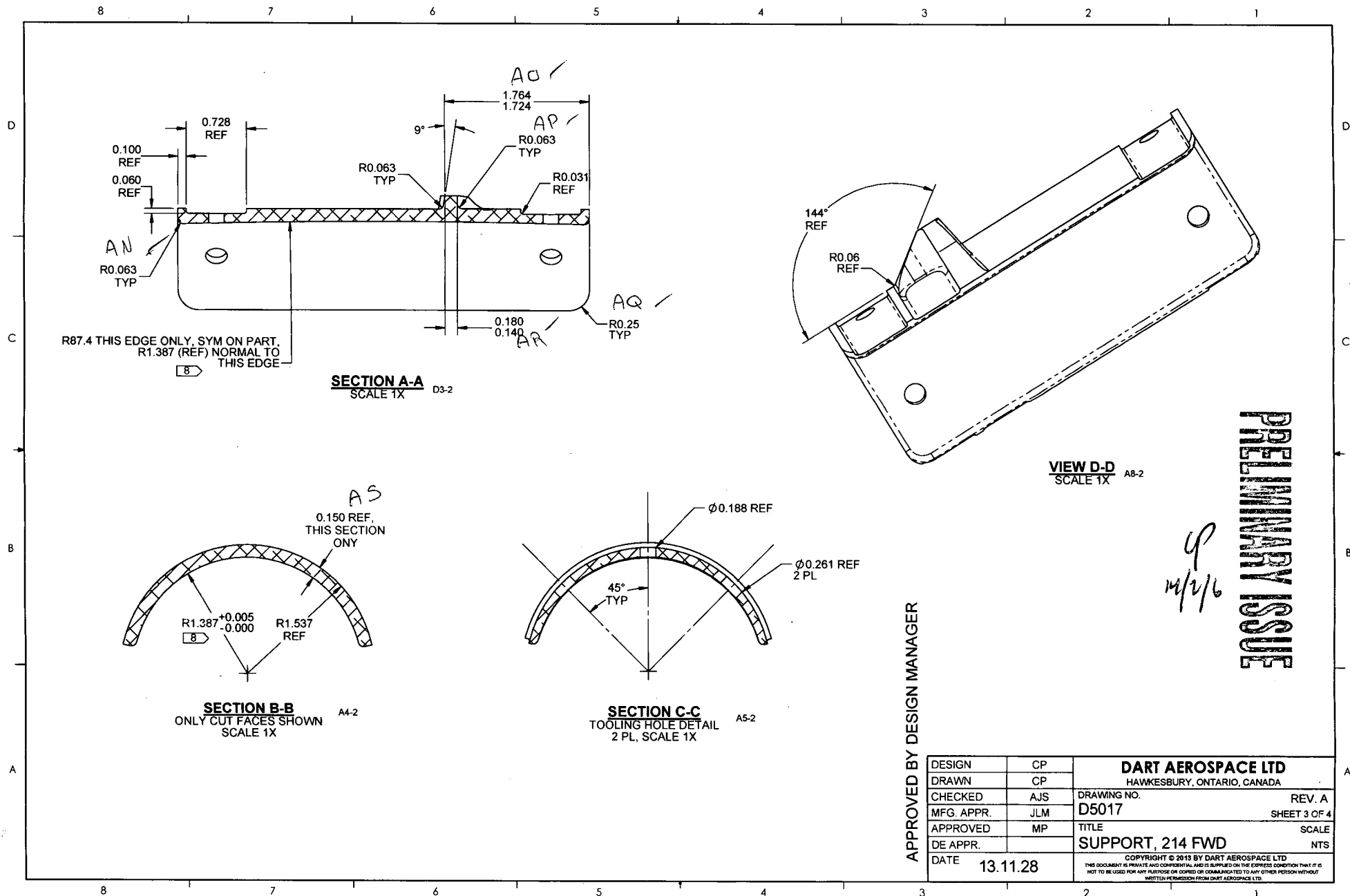
APPROVED BY DESIGN MANAGER

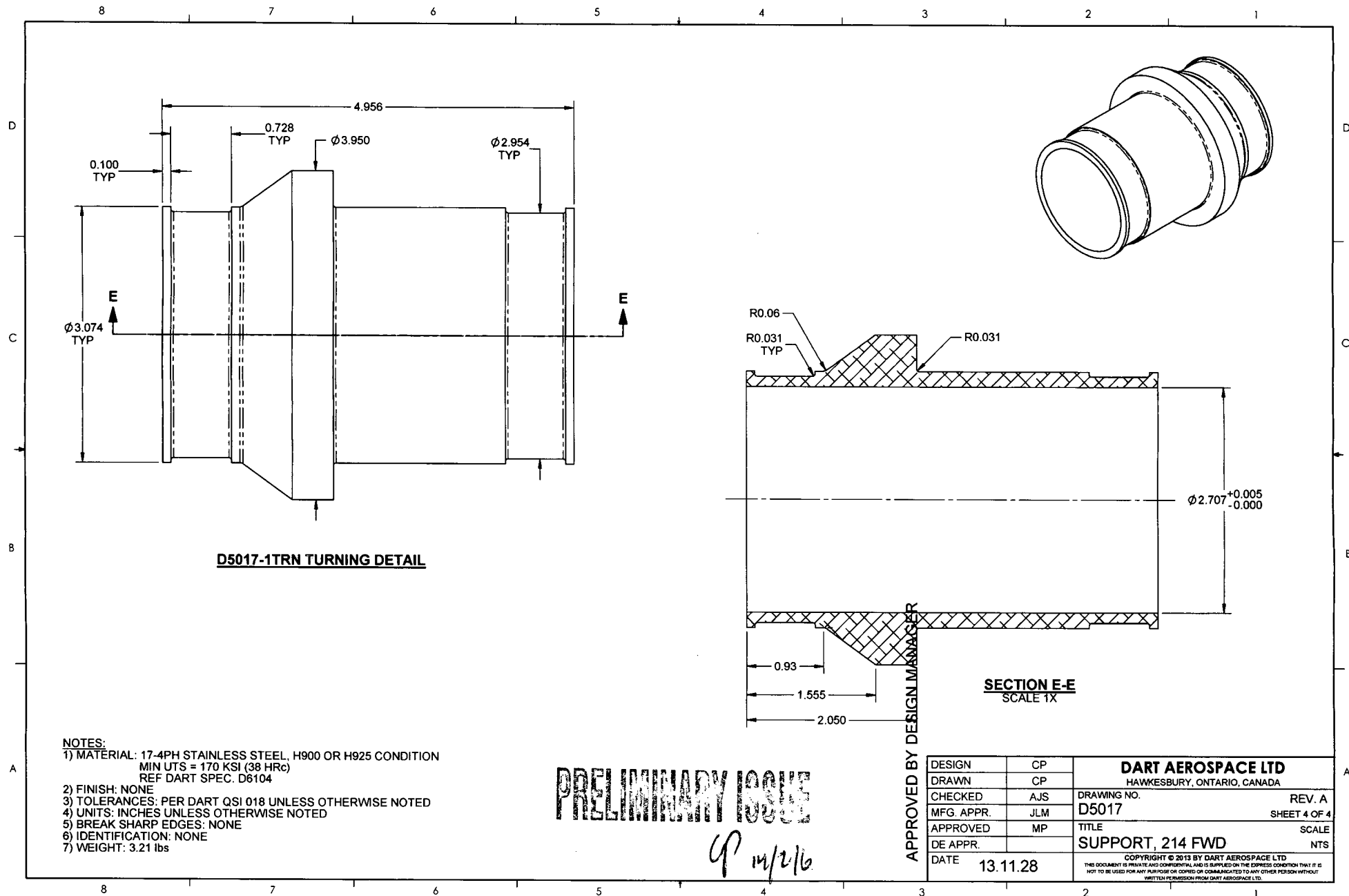
A		NEW ISSUE		CP	13.11.28
REV.	DESCRIPTION			BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED	AJS	DRAWING NO.	REV. A		
MFG. APPR.	JLM	<b>D5017</b>	SHEET 1 OF 4		
APPROVED	MP	TITLE	SCALE		
DE APPR.		<b>SUPPORT, 214 FWD</b>	NTS		
DATE	13.11.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5017	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SUPPORT, 214 FWD	NTS
DATE	13.11.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 111725
<b>Description:</b> Ø Support		<b>Part Number:</b> D507-1
<b>Inspection Dwg:</b> D507	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
<b>HAAS Section</b>								
AA	Ø.187	Ø.193		.190	0.190	0.190	0.190	0.190
AB	Ø.260	Ø.267		.261	0.261	0.261	0.261	0.261
AC	2.985	3.005		2.990	2.990	2.990	2.990	2.990
AD	.390	.490		.485	0.485	0.485	0.485	0.485
AE	.228	.268		.234	0.234	0.234	0.234	0.234
AF	R.490	R.500		.500	0.500	0.500	0.500	0.500
AG	1.205	1.225		1.213	1.213	1.212	1.212	1.214
AH	1.360	1.400		1.368	1.372	1.373	1.375	1.374
AI	.454	.474		.463	0.463	0.463	0.463	0.457
AJ	.041	.061		.052	0.051	0.051	0.051	0.051
AK	.140	.180		.175	0.175	0.175	0.175	0.175
AL	.400	.440		.422	0.422	0.422	0.422	0.422
AM	1.208	1.248		1.213	1.216	1.216	1.220	1.216
AN	.053	.073		.063	0.063	0.063	0.063	0.063
AO	1.724	1.764		1.740	1.744	1.745	1.740	1.741
AP	.053	.073		.063	0.063	0.063	0.063	0.063
AQ	.240	.250		.250	0.250	0.250	0.250	0.250
AR	.140	.180		.152	0.152	0.152	0.152	0.152
AS	.140	.150		.146	0.146	0.146	0.149	0.147
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

<b>Measured by:</b> SL/A.A	<b>Date:</b> 14-2-3
<b>Audited by:</b>	<b>Date:</b>
<b>Preliminary Approval:</b> DAS 12 9-89	<b>Date:</b> 11/2/6

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. E OR LATER  
& INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D205-594 Rev. 4 OR LATER  
REF. CANADIAN STC: SH03-6  
REF. FAA STC: SR01742NY  
REF. EASA STC: 10016828

## PURPOSE:

When installed on 214 aircraft, the support clamps on D205-596-101/-101B/-103/-103B/-105/-105B/-107/-107B crosstubes at CHG 003 (and earlier) interfere with the aircraft's cap assemblies. There is no interference when installed on 204/205/210/212/412 series aircraft.

## CHANGE:

The DSI 9684-011 Support Kit is available from Dart and contains new supports for crosstubes installed on 214 aircraft. The kit can be installed on existing D205-596-101/-101B/-103/-103B/-105/-105B/-107/-107B to correct the interference problem with the aircraft cap assemblies. The new supports reposition the support clamps to avoid the cap assemblies.

For crosstubes on 214 aircraft, the existing D2893-1 & D2940-1 crosstube supports should be replaced with the new D5017-1 & D5018-1 supports per ICA-D205-594 (section 32.3 and 32.4 of rev. 4 or later revision) using a 13.75" spacing. See Figure 1 of this service instruction for reference.

The D5017-1 & D5018-1 supports have been pre-installed on D205-596-101B/-103B/-105B/-107B crosstubes at CHG 004 or later.

For D205-596-101/-107/-201/-207 crosstubes installed on 214 aircraft, it is recommended that the DSI 9684-011 Support Kit be acquired from Dart and installed per this Service Instruction.

## PARTS LIST:

QTY	Part number	Description
X	DSI 9684-011	SUPPORT KIT, 214
2	D5017-1	SUPPORT, 214 FWD
2	D5018-1	SUPPORT, 214 AFT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 14.02.06  
CERT. NO.: SH03-6  
ISSUE NO.: 4

A	NEW ISSUE	CP	14.02.06
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>GP</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>GP</u>		
CHECKED	<u>A.P.</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>N/A</u>	DSI 9684	SHEET 1 OF 3
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	SUPPORT INSTALLATION ON 214 A/C	NTS
DATE	14.02.06	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

The parts lists of IIN-D205-594 and ICA-D205-594 are amended as follows:

**5.3 CROSSTUBE ASSEMBLIES (IIN-D205-594)**  
**32.11.3 CROSSTUBE ASSEMBLIES (ICA-D205-594)**

QTY 596 -101B	QTY 596 -103B	QTY 596 -105B	QTY 596 -107B	Part Number	Description
X				D205-596-101B	CROSSTUBE ASSEMBLY, HI HI FWD (214)
	X			D205-596-103B	CROSSTUBE ASSEMBLY, HI HI AFT (214)
		X		D205-596-105B	CROSSTUBE ASSEMBLY, HI HI FWD (214)
			X	D205-596-107B	CROSSTUBE ASSEMBLY, HI HI AFT (214)

IS:

2		2		D5017-1	SUPPORT, 214 FWD
	2		2	D5018-1	SUPPORT, 214 AFT


WAS:

2		2		D2883-1	SUPPORT
	2		2	D2940-1	SUPPORT





**WEIGHT AND BALANCE:**

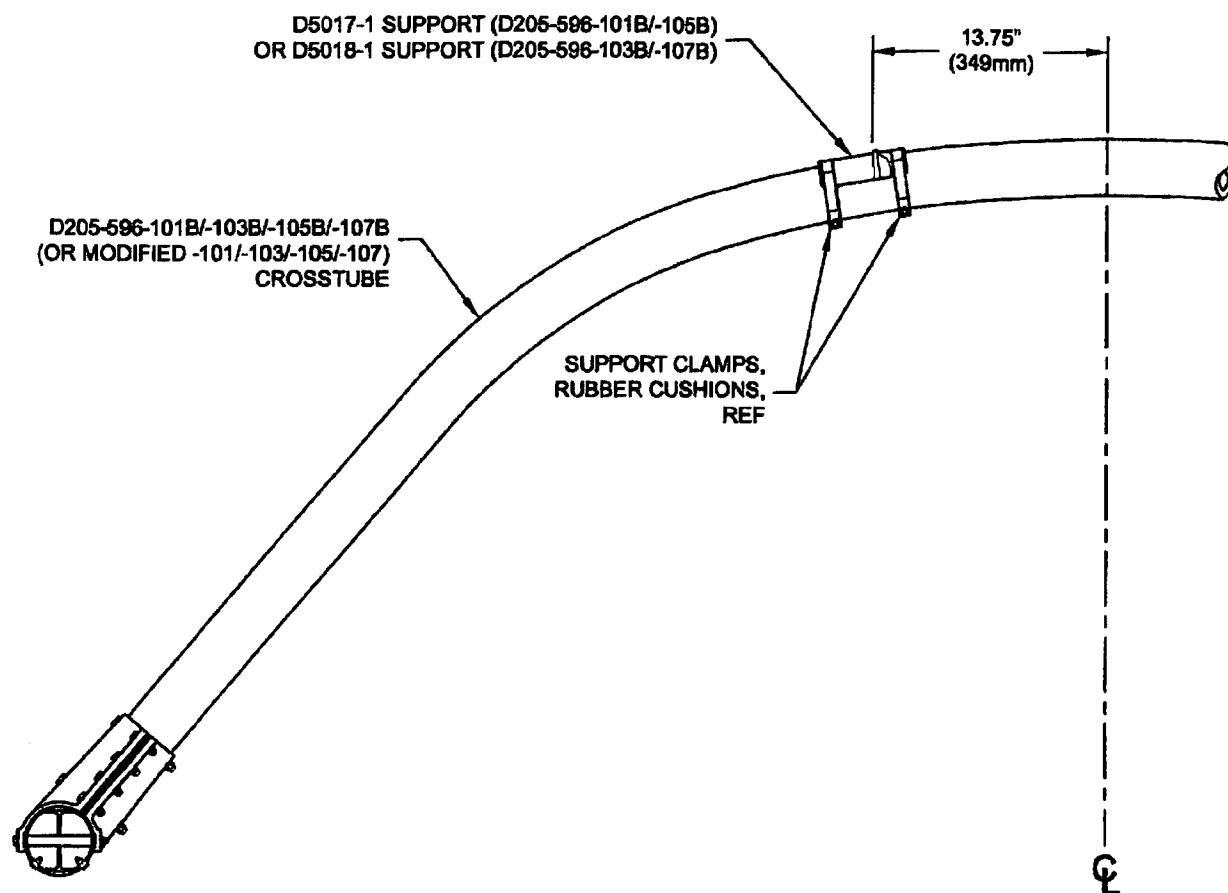
There is no change to the weight and balance associated with DSI 9684-011 Support Kit.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
  
BY: D. SHEPHERD (DE # 02)

DATE: 14.02.08  
CERT. NO.: SH03-6  
ISSUE NO.: 4

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9684	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT INSTALLATION ON 214 A/C	NTS
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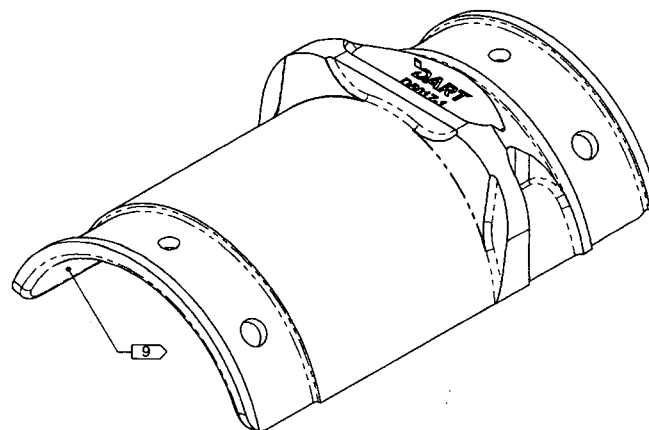
**FIGURE 1:**  
**SUPPORT INSTALLATION ON 214 AIRCRAFT**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
*[Signature]*  
BY: D. SHEPHERD (DE # 02)

DATE: 14.02.06  
CERT. NO.: SH03-6  
ISSUE NO.: 4

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT INSTALLATION ON 214 A/C	NTS
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**D5017-1 SUPPORT, 214 FWD**

**NOTES:**

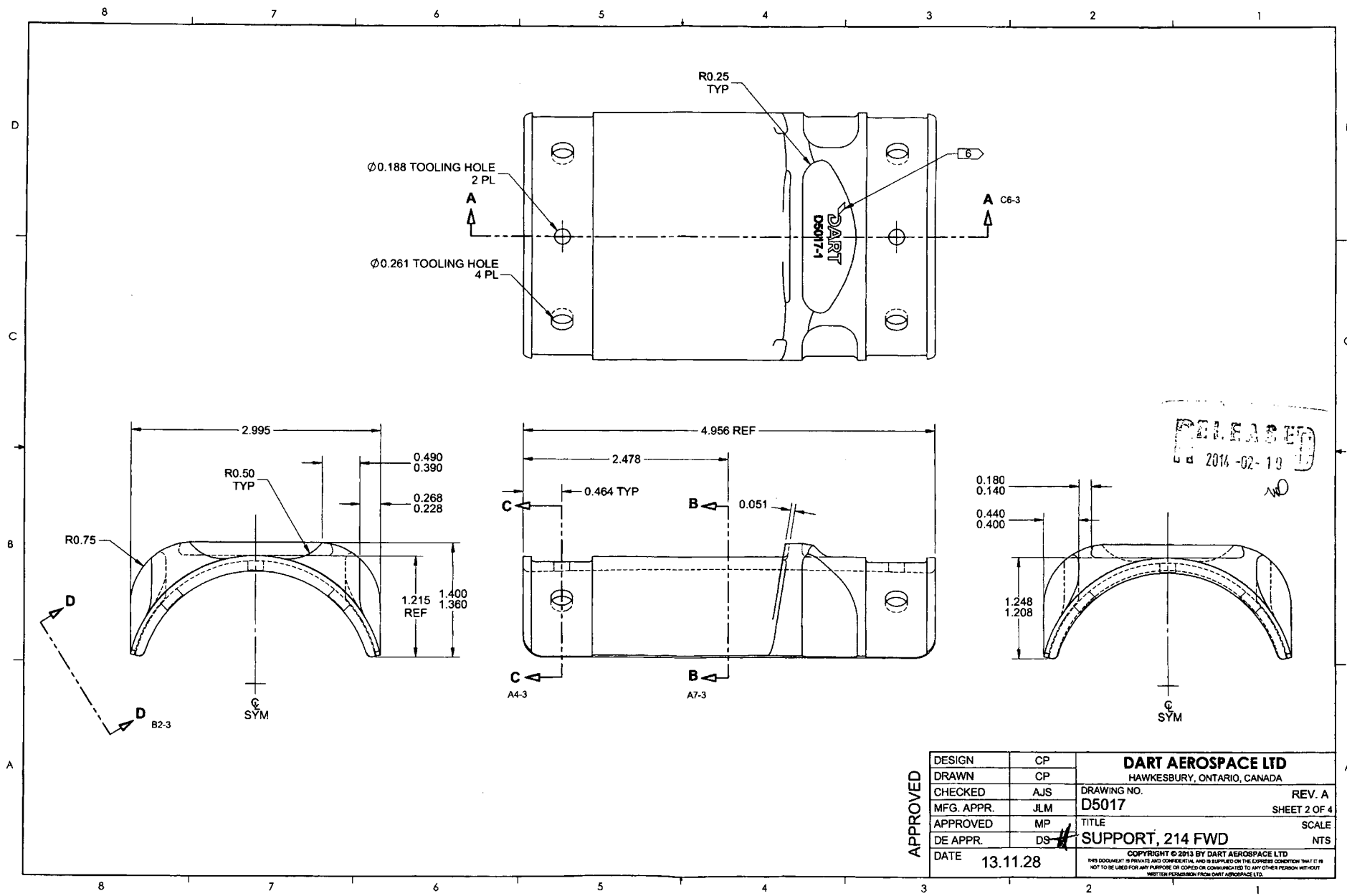
- 1) MATERIAL: MAKE FROM D5017-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N "D5017-1" IN THIS AREA WITH 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3
- 7) WEIGHT: 0.88 lbs
- 8) INNER CONCAVE SURFACE HAS A CONSTANT RADIUS OF R1.387 (REF) CUT ALONG AN R87.4 (REF) PATH (ie. TORUS SHAPE)
- 9) FOR ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIV.). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

**RELEASED**  
13 2014-02-10

A		NEW ISSUE		CP	13.11.28
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 4	
DRAWN	CP				
CHECKED	AJS	DRAWING NO.		REV. A	
MFG. APPR.	JLM	D5017		SCALE	
APPROVED	MP	TITLE		NTS	
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DATE	13.11.28				

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2014-02-13

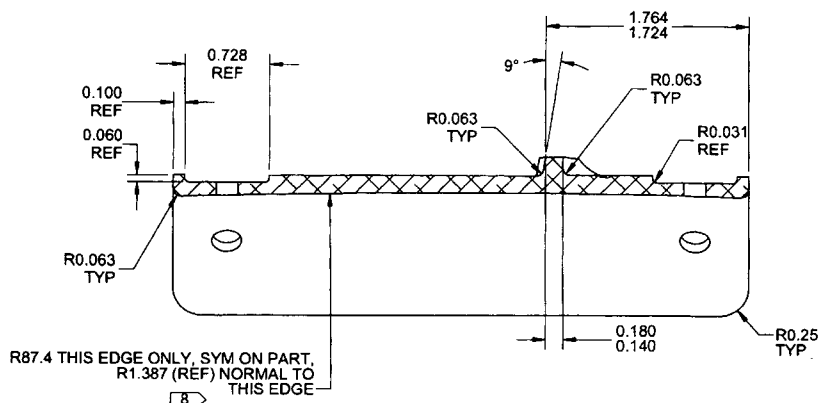
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	DRAWN	CP		
	CHECKED	AJS	DRAWING NO.	REV. A
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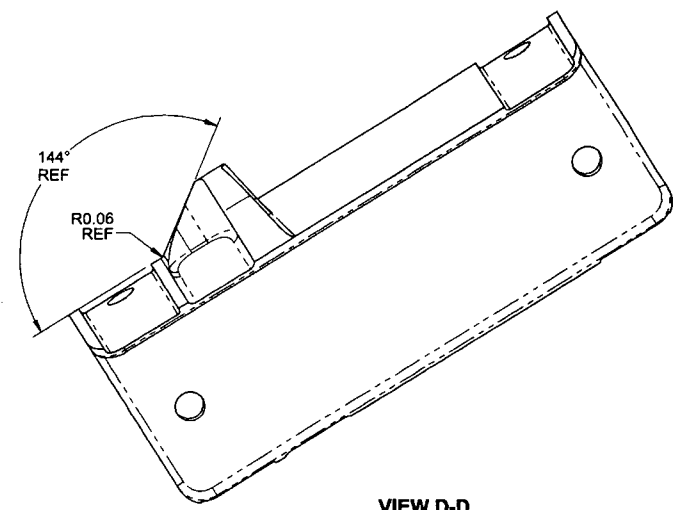
8 7 6 5 4 3 2 1

D  
C  
B  
A

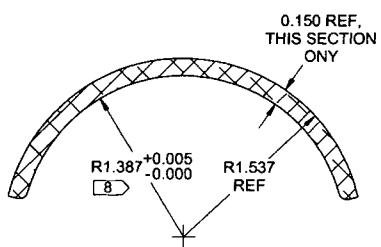
D  
C  
B  
A



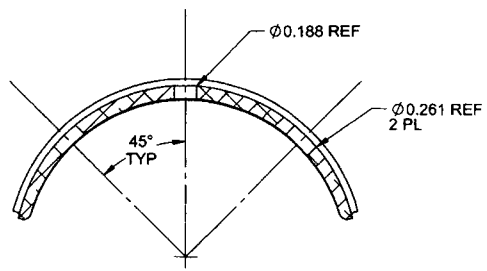
**SECTION A-A**  
SCALE 1X D3-2



**VIEW D-D**  
SCALE 1X A8-2



**SECTION B-B**  
ONLY CUT FACES SHOWN  
SCALE 1X A4-2

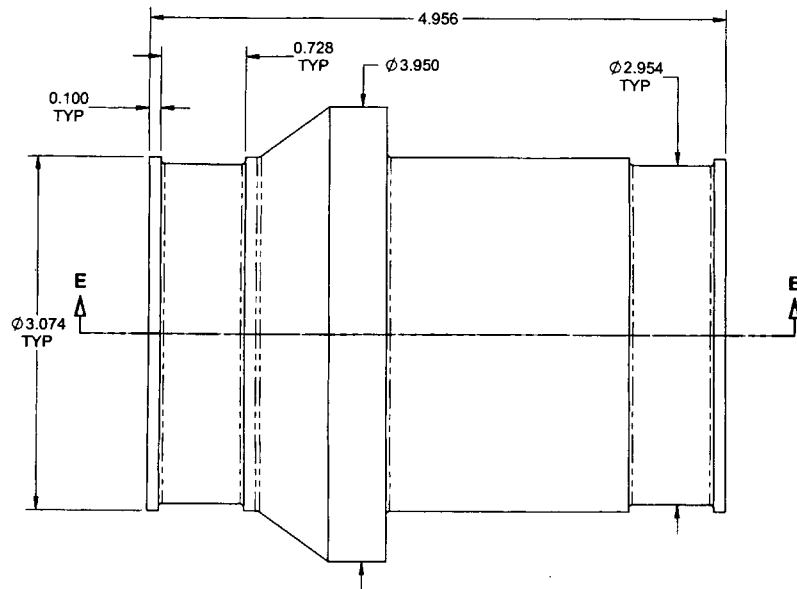


**SECTION C-C**  
TOOLING HOLE DETAIL  
2 PL, SCALE 1X A5-2

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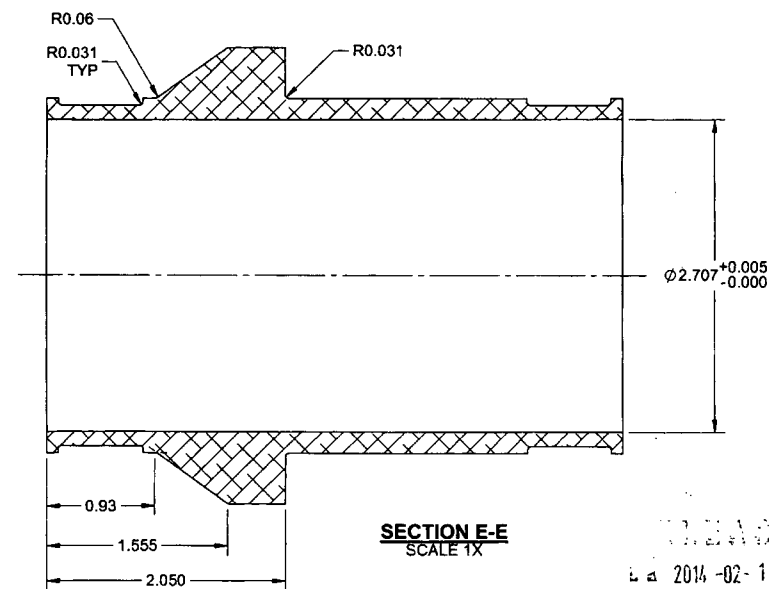
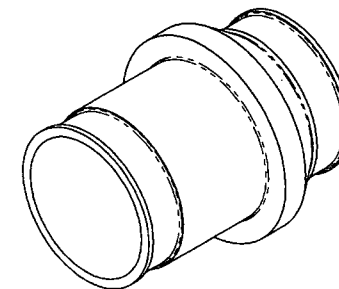
8 7 6 5 4 3 2 1



**D5017-1TRN TURNING DETAIL**

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRc)  
REF DART SPEC. D6104
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.21 lbs



**SECTION E-E**  
SCALE 1X

2014-02-14

APPROVED

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